

BLUE

Dart Aerospace Ltd.

Date: Friday, 19/12/2008 8:15:01 AM
 User: Melanie Fautoux

Process Sheet

Customer :	CC-DAR01 Dart Aerospace Ltd.	Drawing Name :	BLUE
Job Number :	44191		
Estimate Number :	10804		
P.O. Number :		Part Number :	D26511
This Issue :	19/12/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2651-1
First Issue :	/ /	Project Number :	
Previous Run :	43382	Drawing Revision :	
	Type :	Material :	
	MACHINED PARTS	Due Date :	26/12/2008
Written By :		Qty:	200
Checked & Approved By :	<u>MF 08-12-19</u>	Um:	Each
Comment :			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0500	6061-T6 Round Bar .500"
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Comment: Qty.: 0.0421 f(s)/Unit Total : 8.4210 f(s)

Material: 6061-T6 (QQ-A-225/8) 0.500" Dia
 (M6061T6R0500)

Batch: M109396

mf 08/12/20

(213)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Turn as per Folio FA219 and Dwg D2651

2- Deburr

mf 08/12/20

(213)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mf 08/12/20

(213)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J. 08.12.22

(213)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr ias per dwg D2651

mf 08/12/20

(213)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BLUE

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Part Number: D26511

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(213)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 08/12/22

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: -PRIME B 110199

-PAINT DELFLEET BLUE B 110077

-CLEAR DELFLEET B 110169

only large section necessary

2T 08-12-22

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT spray painting

M 08 12 23 (213)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(213X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

F P - A M 08/12/23

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/23 JH

Job Completion



mf 08-12-23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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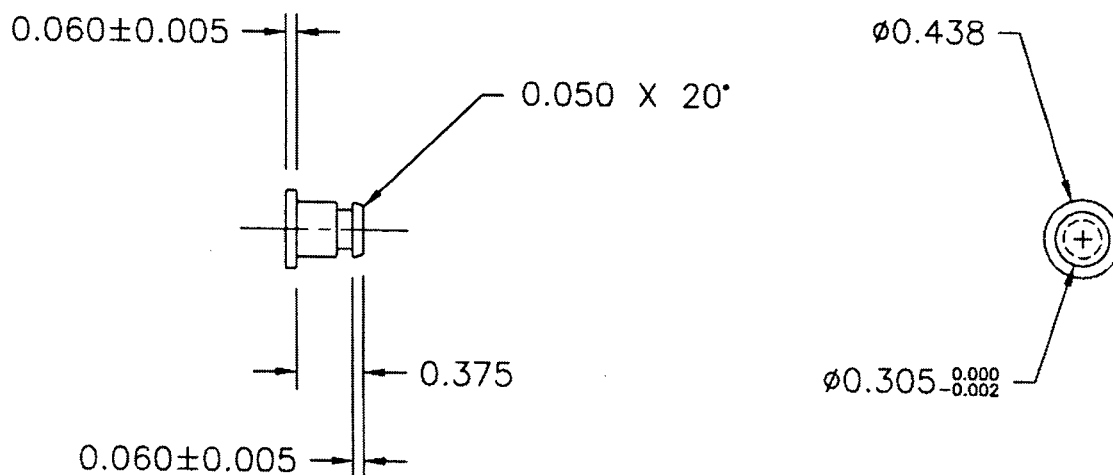
NOTE: Date & initial all entries



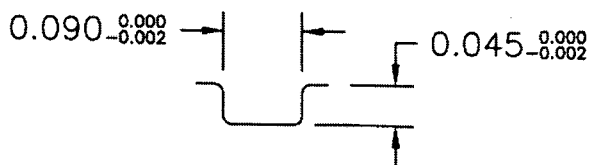
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

RELEASED
03.12.19 #

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



REFERENCE ONLY

* 44191

D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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